

Work Order ID 83459

Wednesday, April 18, 2012 8:44:52 AM

83459

Page 1

Item ID: D4151-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Hardpoint Plate

Start Date: 4/18/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/18

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4151	C					(16)			

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4151

Prog Rev: EDwg Rev: E

304 .125

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-7

B12-5-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83459

Wednesday, April 18, 2012 8:44:52 AM

83459

Page 2

Item ID: D4151-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Hardpoint Plate
 Start Date: 4/18/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC8- Inspect parts - second check	0.00							
120		0.00							
QC	Memo								
Quality Control									

150	Identify as per dwg & Stock Location: 8134	0.00							
150		0.00							
Packaging	Memo								
Packaging									

160	QC21- Final Inspection - Work Order Release	0.00							
160		0.00							
QC	Memo								
Quality Control									

12-05-7

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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 18, 2012 8:44:56 AM

Page 1

Work Order ID: 83459

83459

Parent Item: D4151-3

D4151-3

Parent Item Name: Upper Hardpoint Plate

Start Date: 4/18/2012

Required Date: 4/25/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	72.0900	0.055	0.694737			

M304S11GA

**

1812-5-7

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

72.09

121070-

5.59

121380

66.5

121070

14

W/O:		WORK ORDER CHANGES					
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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	11.01.28	Dimensions updated per Dwg Rev C	KJ	

Dart Aerospace Ltd

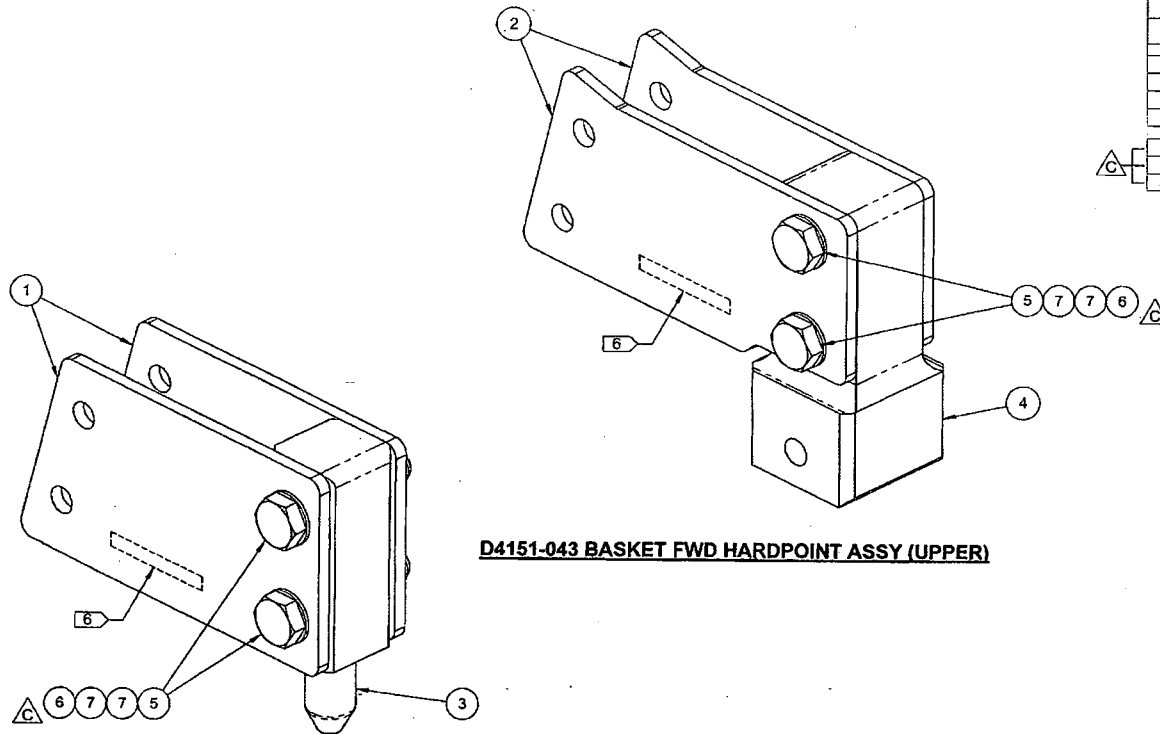
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D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)

D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83459 MW

12/04/18 **RELEASED**

2011-01-08

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C5-3); Ø0.250 WAS Ø0.191 (C9-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.78 (B3-3) AND 1.84 WAS 1.80 (C1-3) TO PRESERVE 1.5SD. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20615-4M20 (ZN C3-1, D3-1 & B6-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.08.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C
SHEET 1 OF 3
TITLE **BASKET FWD HARDPOINT** SCALE NTS

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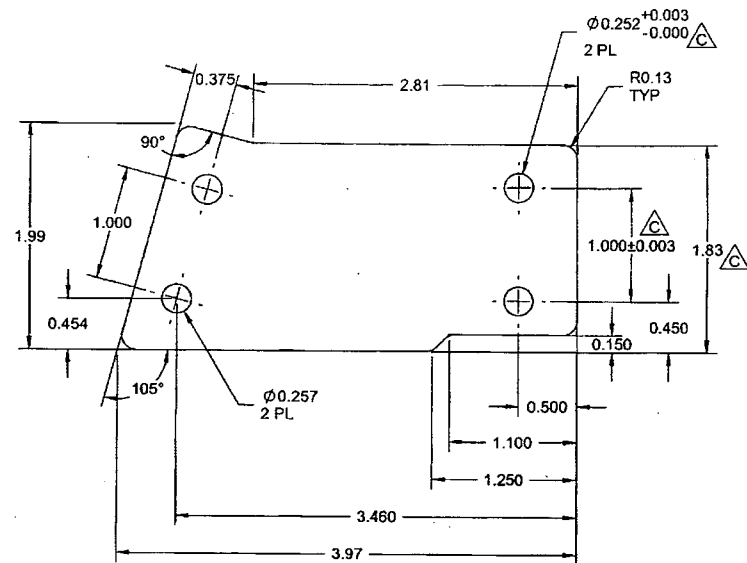
NOTE: Date & initial all entries

Technical drawing of a rectangular plate with the following dimensions and features:

- Overall width: 3.128
- Overall height: 2.00
- Top edge offset: 0.375
- Left edge offset: 0.50
- Right edge offset: 0.50
- Internal vertical spacing: 1.000
- Internal vertical spacing tolerance: 1.000 ± 0.003 (indicated by a triangle C)
- Internal angle: 105°
- Internal offset: 0.375
- Bottom edge offset: 0.375
- Bottom edge radius: R0.13 TYP
- Bottom edge label: 2 PL
- Bottom edge label: $\phi 0.257$
- Bottom edge label: 2 PL
- Bottom edge label: 3.66 REF
- Bottom edge label: $\phi 0.252^{+0.003}_{-0.000}$ (indicated by a triangle C)
- Bottom edge label: 2 PL
- Bottom edge label: TYP

0.125
REF

D4151-1 LOWER HARDPOINT PLATE



0.125
REF

D4151-3 UPPER HARDPOINT PLATE

RELEASED
2011-01-18
JMD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
- D4151-1 = 0.24 lbs
 - D4151-3 = 0.23 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
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W/O:		WORK ORDER CHANGES					
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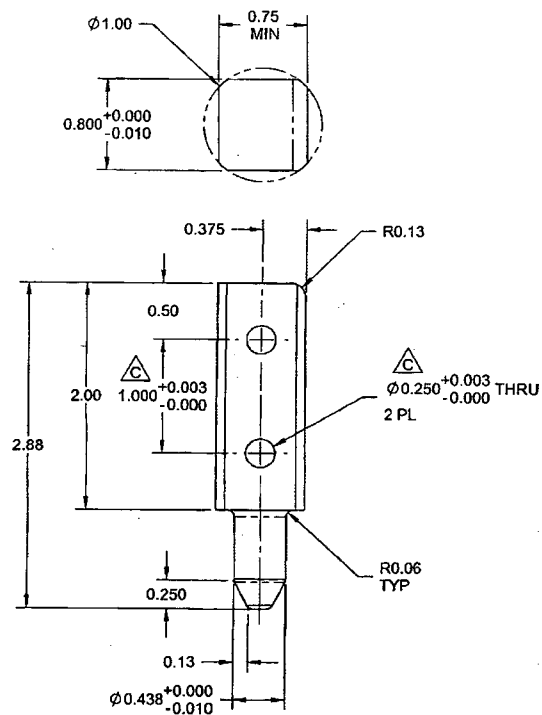
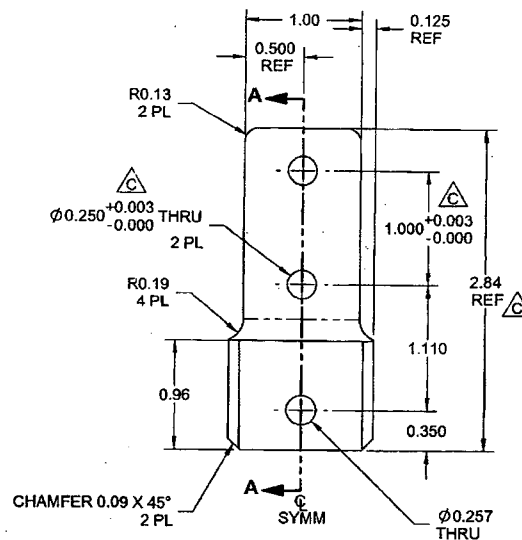
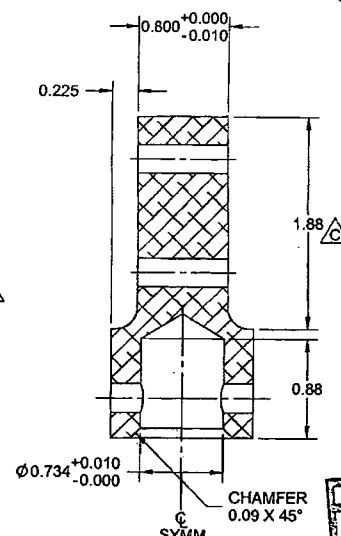
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83459

**D4151-5 FWD BASKET INSTL STUD (LOWER)****D4151-7 FWD EYEBOLT RECEIVER (UPPER)****SECTION A-A****NOTES:**

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D4151	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE BASKET FWD HARDPOINT	SCALE
DE APPR.			NTS
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R 2011-01-01
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